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APPLICANT: Scott L. BARHAM

TITLE: FILTRATION AID FOR THE BAYER PROCESS

**INFORMATION SHEET**

**INVENTOR(S):**

1. Scott L. BARHAM  
4 McGregor Road  
Palmy Ra Wa 6157, Australia

**PRIORITY (35 USC 119):**

Based on Australian Application PP8258 filed January 20, 1999.

Case 5594

## TECHNICAL FIELD

The present invention relates to treating agents and particularly to treating agents for  
5 filtration of caustic sodium aluminate solutions from the Bayer process.

## BACKGROUND ART

In the Bayer process, alumina is refined from bauxite ores. The process comprises  
digesting the ore in a caustic solution to extract alumina, clarifying the liquor to remove  
caustic insoluble red mud material and precipitating alumina crystals as its trihydrate form  
10 from the clarified liquor. Clarifying the liquor involves separating the solid particles from  
the liquor by settling and if necessary, filtration.

The clarified, filtered liquor is then cooled until it becomes super-saturated and  
seeded with crystals of alumina trihydrate. Alumina is precipitated as the trihydrate in  
tanks and the solids are classified by particle size. The coarse fraction of alumina  
15 trihydrate (primary) is then dewatered eg by rotary vacuum filters and washed to reduce its  
soda level. The alumina product is then transferred to calciners where any free or  
combined water is removed if it is intended that the alumina be used in the manufacture of  
aluminium metal. If the alumina is to be used in other applications, some of the free water  
will be removed but not necessarily the water of hydration.

20 As discussed in US patent no 5,091,159 (incorporated herein by reference), it has  
been found that dextran is a particularly suitable treating agent for filtration. The dextran is  
added to the liquor, which preferably already contains a calcium aluminate filter aid, in  
quantities of 0.5-15 mg/l as the only treating agent. This addition of dextran has been  
shown to give substantial improvements in filtration time.

The present invention seeks to overcome at least some of the disadvantages of the prior art or at least provide a commercial alternative thereto.

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comprising a blend of starch and another polysaccharide.

10 consisting of pullulan, dextran, alginate, zooglan, lactan or mixtures thereof.

aluminate and most preferably a 12% aqueous suspension of calcium aluminate.

15 Kelly pressure filter. Such a filter aid may not be required in all circumstances, eg, where a

preferably up to 5 ppm of the polysaccharide and up to 200-300 ppm of starch.

20 to starch ratio of between 9:1 and 1:9.

aluminate solution and an insoluble red mud fraction which is then subjected to a thickener

and separation step to produce a thickener overflow, said thickener overflow being

subjected to filtration, the improvement comprising providing a blend of starch and another polysaccharide to the thickener overflow as a treating agent prior to said filtration.

The present applicant has surprisingly found that at least part of the polysaccharide normally used as a treating agent in the filtration step of the Bayer process can be replaced  
5 with starch without any substantial loss in filterability. Indeed the addition of certain blends of polysaccharide and starch as a treating aid may result in increased filterability of the liquor as compared to polysaccharide alone as a filter aid.

Clearly this has significant advantages since starch is only a fraction of the cost of the aforementioned polysaccharides. Any replacement of the polysaccharide by a low-cost  
10 product such as starch will substantially increase the commercial viability of the process.

Unless the context clearly requires otherwise, throughout the description and the claims, the words 'comprise', 'comprising', and the like are to be construed in an inclusive sense as opposed to an exclusive or exhaustive sense; that is to say, in the sense of "including, but not limited to".

## 15 BEST MODE FOR CARRYING OUT THE INVENTION

To illustrate the advantages of the invention the following results are presented by way of example only.

### **Test Series A and B**

Filtration tests were conducted on the green liquor at a typical alumina plant using  
20 the Bayer process plant, the results of which are shown in the table below.

The polysaccharide used was dextran as a 7% aqueous solution. The starch component was a 10% (100 g/l) aqueous solution produced by adding powder to 10 g/l sodium hydroxide and agitating at 60° for 15 minutes.

Two series of test were conducted. Series A had 10 tests (1A - 10A) and series B had 6 tests (1B-6B).

As shown in Table 1, for series A several different blends of the treating agent were used in the filtration tests. Test number 2A uses a simple aqueous solution of dextran with no addition of starch. Tests 4A, 6A and 8A use varying dextran/starch ratios and test 10A uses a simple aqueous solution of starch. Each test was compared with a corresponding blank which did not use any treating agent.

As shown in Table 2, for series B, tests 2B, 4B and 6B similarly use varying dextran/starch ratios.

The times for filtering various quantities (50 ml, 100 ml and 150 ml) were measured. The filtration rates were then calculated and these rates compared with the corresponding blank to provide a percentage measure of the increase/decrease flotation rates (%50, %100 and %150).

It is clear from the results below that the blending of the polysaccharide treating agent with starch provides no real significant decrease in filterability of the green liquor and in fact in some instances provides an advantage.

For test series A when using an aqueous solution of dextran as the treating agent, there is an average improvement in filterability of around 52%. When starch, however, is mixed with the dextran there is a slight reduction in filterability but a substantial cost saving. Tests 4A, 6A and 8A have an average improvement in filterability over their corresponding blank of around 37%, 41% and 46%. This compares very favourably with the pure dextran treating agents.

Series B testing provided even better results. Test 2B shows an average improvement in filterability of 46.1% where the treating agent is an aqueous solution of

dextran. Tests 4B and 6B show of 55% and 45% improvement in filterability when the dextran is mixed with 50% and 75% respectively of starch. This of course compares extremely favourably with the dextran treating agent.

Accordingly, it is clear that even small additions of starch to the polysaccharide  
5 treating agent provide significant cost saving without any substantial reduction in the filterability of the green liquor. These results are quite surprising since, as shown in test 10A, using the treating agent made purely of starch ie without any dextran, provides no improvement in the filterability of the green liquor over an untreated liquor.

It is envisaged that the quantity of starch added to the polysaccharide may be quite  
10 high, even as high as 9 times the quantity of polysaccharide since, as shown in tests 8A and 6B which have a dextran/starch ratio of 25/75, there is minimal effect on the filterability of the green liquor as compared with the pure dextran treating agent.

### Test Series C

Reference is also made to the results of Test Series C shown in Table 3 and Figure 1  
15 which ~~display~~ the effect of a dextran/starch ratio in liquor filtration.

These tests were conducted using a Nalco pressure filter. A 13% aqueous solution of dextran (85711) was mixed in various ratios with a 14% by weight solution of starch (PE200).

As a measure of the effectiveness of the treating agent, the resistance to filtration of  
20 the filter medium (i.e. wire or cloth support) and the resistance to filtration of the cake (red mud) built up on the filter medium were both measured. Results are shown in Table 3 and Figure 1. Comparing test runs 2C, 4C and 5C which use the dextran/starch blend, it is apparent that there is little variation in the filter medium resistance or cake resistance as compared with run 1C which uses an aqueous solution solely of dextran as the treating

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Table 1 - Test Series A

TEST	PRODUCT	PRODUCT RATIO	DOSE (PPM)	TIME FOR 50 MLS	TIME FOR 100 MLS	TIME FOR 150 MLS	RATE 50	RATE 100	RATE 150	% 50	% 100	% 150	Average
1A	Blank	-	0	50	141	278	1.00	0.71	0.54				
2A	85715/PE200	100/0	5	32	94	185	1.56	1.06	0.81	56.3	50.0	50.3	52.2
3A	Blank	-	0	46	120	210	1.09	0.83	0.71				
4A	85715/PE200	75/25	5	34	86	155	1.47	1.16	0.97	35.3	39.5	35.5	36.8
5A	Blank	-	0	57	140	238	0.88	0.71	0.63				
6A	85715/PE200	50/50	5	39	100	175	1.28	1.00	0.86	46.2	40.0	36.0	40.7
7A	Blank	-	0	57	137	233	0.88	0.73	0.64				
8A	85715/PE200	25/75	5	36	96	171	1.39	1.04	0.88	58.3	42.7	36.3	45.8
9A	Blank	-	0	57	131	216	0.88	0.76	0.69				
10A	85715/PE200	0/100	5	58	131	215	0.86	0.76	0.70	-1.7	0.0	0.5	-0.4

85715 - 7% aqueous solution of dextran

PE200 - 10% (100gpl) aqueous solution producing by adding powder to 10 gpl NaOH and agitating at 60°C for 15 mins



Table 2 - Test Series B

TEST	PRODUCT	PRODUCT RATIO	DOSE (PPM)	TIME FOR 50 MLS	TIME FOR 100 MLS	TIME FOR 150 MLS	RATE 50	RATE 100	RATE 150	% 50	% 100	% 150	Average
1B	Blank	-	0	75	190	335	0.67	0.53	0.45				
2B	85715/PE200	100/0	5	52	131	225	0.96	0.76	0.67	44.2	45.0	48.9	46.1
3B	Blank	-	0	76	185	316	0.66	0.54	0.47				
4B	85715/PE200	50/50	5	45	123	215	1.11	0.81	0.70	68.9	50.4	47.0	55.4
5B	Blank	-	0	82	188	320	0.61	0.53	0.47				
6B	85715/PE200	25/75	5	52	135	230	0.96	0.74	0.65	57.7	39.3	39.1	45.4

PE200 made as 10% (100gpl) solution by adding powder to 10gpl NaOH and agitating at 60°C for 15 mins.  
 85715 obtained from laboratory retain.  
 Combination of products make by simply blending together

Table 3 - Test Series C

Run#	%PE200	85711/ PE200**	Medium Resistance, l/m		Cake Resistance, m/kg	
			Value	Stand. Error	Value	Stand. Error
1C	0	100/0	1.93E+11	2.0E+08	1.88E+11	1.0E+09
2C	25	75/25	1.90E+11	1.6E+08	1.44E+11	9.4E+08
4C	50	50/50	9.34E+10	2.0E+08	9.44E+10	8.0E+08
5C	75	25/75	1.97E+11	1.3E+08	2.27E+11	6.1E+08
6C	100	0/100	2.27E+11	2.3E+08	3.33E+11	1.1E+09
3C		Blank	1.86E+11	1.9E+08	3.67E+11	8.8E+08

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